

**Work Order ID 65638**

January 20, 2011 2:14:37 PM



Page 1

Item ID: D3041-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/20/11

Start Qty: 20.00



Cust Item ID:

Required Date: 2/18/11

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 Extrusion: 1.250" Long

*Cut @ meter*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

~~HAAS CNC vertical machine #1~~

Machine per folio FA153

DWG REV:

FOLIO REV:

*issue P10 13326 meter machine as per drawing D3041 REV.C*

120

0.00

~~QC2-Inspect parts off machine FA1/FA1B~~QC *PK*

Memo

0.00

Quality Control

*rec'd + inspect for transit damage.**1/24/11 (20)*

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January 20, 2011 2:14:37 PM

Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11 03 10 (20)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml/AE 11 03/15 (20)

150

QC Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BR - 11-3-15

Pho →

Dart Aerospace Ltd

W/O: 65638		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/27/14	15	perm. change change QIS to QIS inspection					S 11/28/14

Part No: D3041-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/27/14								

NOTE: Date & initial all entries

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January 20, 2011 2:14:38 PM



Page 3

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Stop



Item Name: Clamp

Start Date: 1/20/11

Start Qty: 20.00



Cust Item ID:

Required Date: 2/18/11

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 115951

Memo

0.00

Mask inside of 0.8120" diameter hole START TIME:  
3:35 OVEN TEMPERATURE: 320° FINISH  
TIME: 4:05

20 BR 11-3-14

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

20 d 11-03-15

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- Press D2611 bearing into lug as per Dwg D3041 2- Stake bearing into place  
as per Dwg D3041 \*\*PLEASE SEE JASON BEFORE PRESSING  
BEARINGS FOR NEW TOOLING \*\*

ES 11/03/15 (20)

# Work Order ID 65638

January 20, 2011 2:14:38 PM

Page 4

Item ID: D3041-1

Accept

Revision ID:

Item Name: Clamp

Start Date: 1/20/11 Start Qty: 20.00

Required Date: 2/18/11 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 463

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

cents

(+20)

11/3/16 200

11/3/16

MF 1-03-16

# Picklist Print

January 20, 2011 2:14:36 PM

Page 1

Work Order ID: 65638

Parent Item: D3041-1

Parent Item Name: Clamp



Start Date: 1/20/11

Required Date: 2/18/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: as per revC1 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			180	f	534.1914	0.0833	1.753684			

Location	Loc Qty	Loc Code
MAT06	534.1914265	
43722	180	
45800	66.1914265	
63005	288	

D2611  Bearing		Manufactured	No			100	Each	20.0000	1	20			
----------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

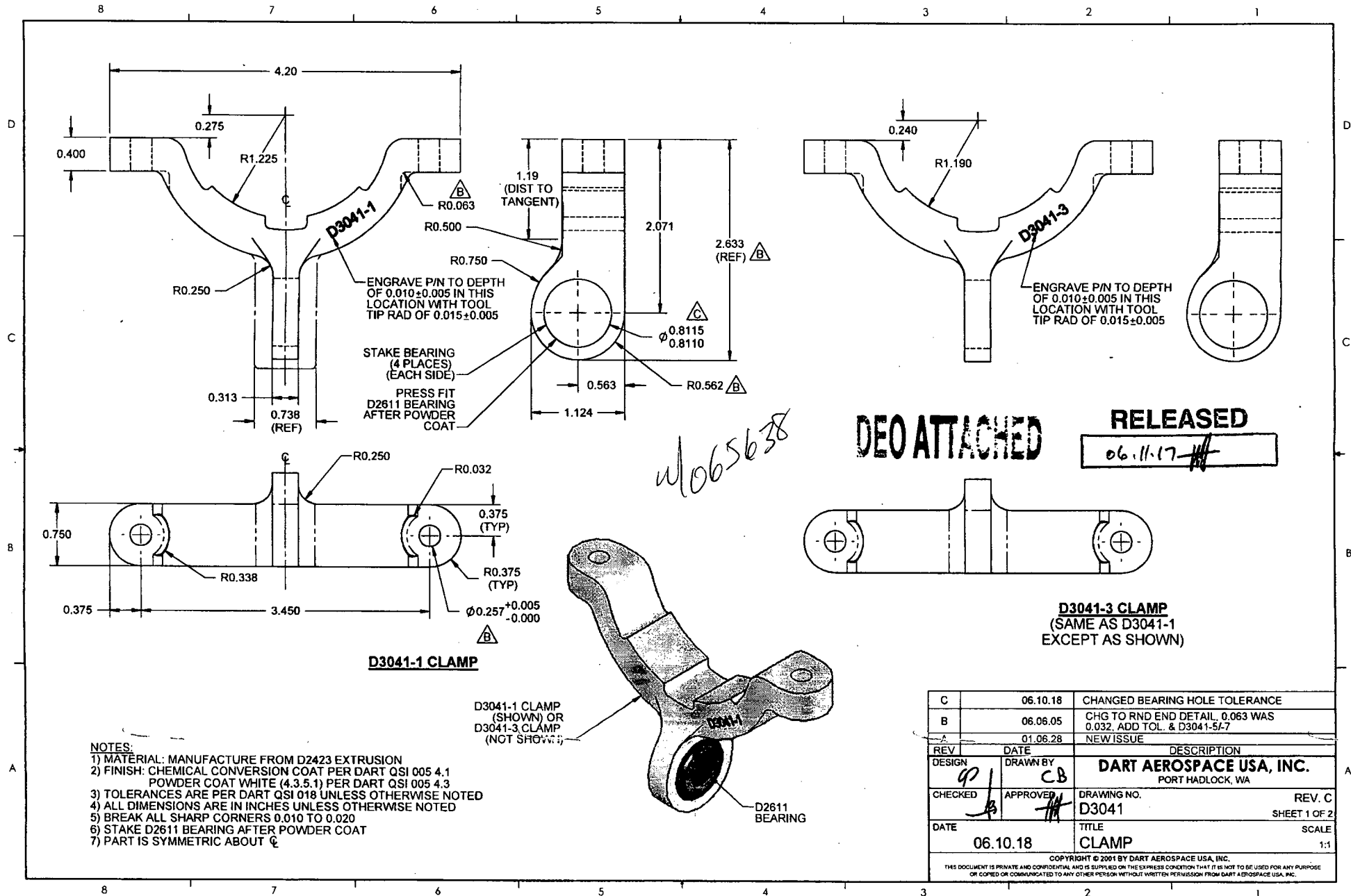
Location	Loc Qty	Loc Code
ST020	20	
51262	20	

D3041-1P

X20

1/24/11 (20)

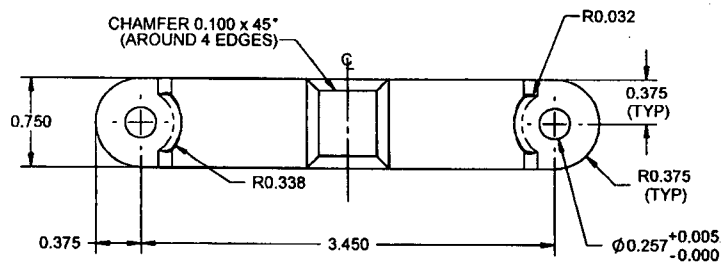
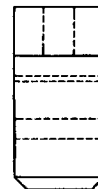
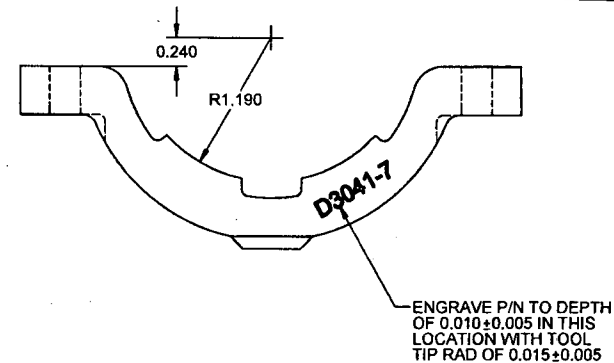
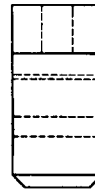
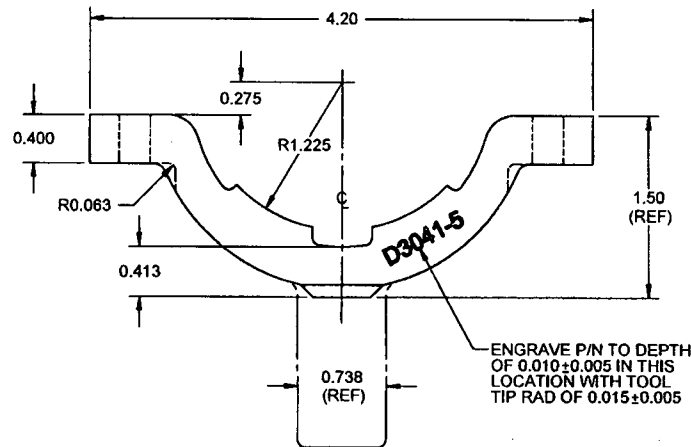
B65640 (8)



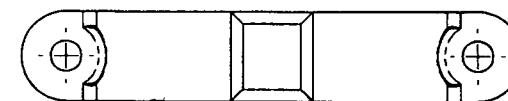
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## RELEASED

06.11.17

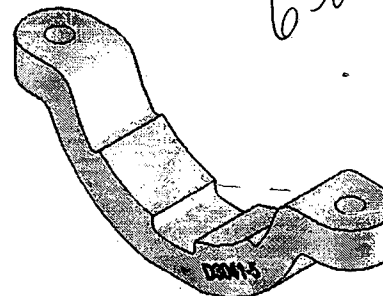


**D3041-5 CLAMP**



65638

**D3041-7 CLAMP**  
(SAME AS D3041-5  
EXCEPT AS SHOWN)



### NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT  $\phi$

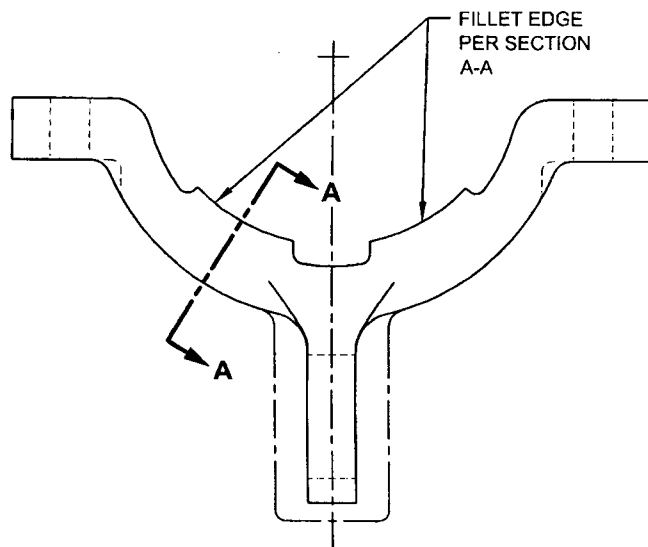
DESIGN 901	DRAWN BY CB	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP	SCALE 1:1	

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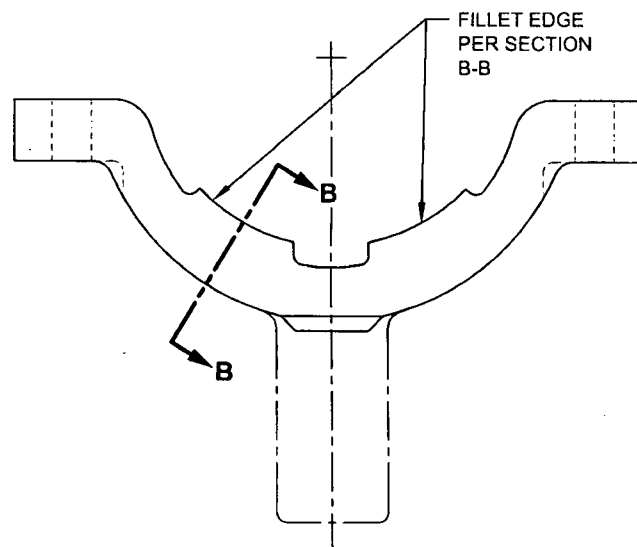
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13			

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



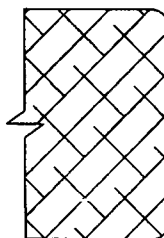
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX  
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

**RELEASED**  
09/07/07

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 65638
<b>Description:</b> Clamp		<b>Part Number:</b> D3041-1
<b>Inspection Dwg:</b> D3041	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030					
0.275	+/-0.010					
R1.225	+/-0.010					
0.400	+/-0.010					
R0.250	+/-0.010					
0.313	+/-0.010					
R0.063	+/-0.010					
1.19	+/-0.030					
1.124	+/-0.010					
0.563	+/-0.010					
R0.562	+/-0.010					
Ø0.8115 - 0.8110	N/A					
2.071	+/-0.010					
0.750	+/-0.010					
0.375	+/-0.010					
R0.338	+/-0.010					
3.450	+/-0.010					
Ø0.257	+0.005-0.000					
R0.375	+/-0.010					
0.375	+/-0.010					
R0.032	+/-0.010					
R0.250	+/-0.010					

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

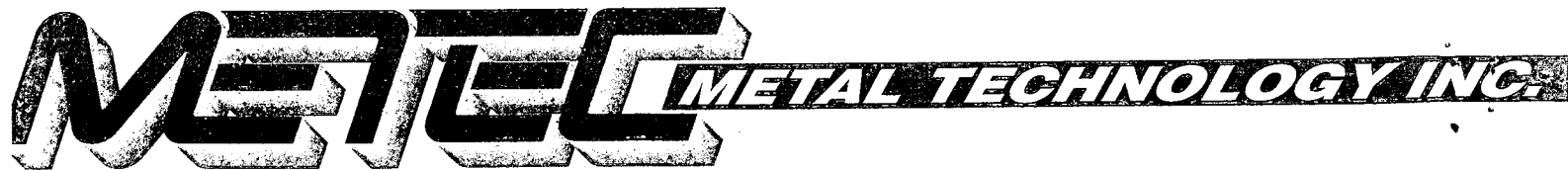
**Delivery Slip No.:** 17816  
**Date:** Mar 09, 2011  
**Page:** 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13326	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug Material supplied by DART: D2423 B45800	Each	30		
D3910-1 Crosstube Lug Material supplied by DART: D2423 B	Each	30		
D4091-1 Lug Material supplied by DART: D2423 B	Each	24		
D3041-1 Clamp Material supplied by DART: D2423 B63005	Each	20	20	
D3041-3 Clamp Material supplied by DART: D2423 B63005	Each	20	12	

Received by \_\_\_\_\_

**Thank you for your order!**



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

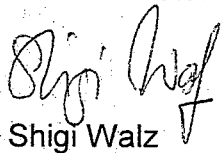
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3041-1	Clamp	13326

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, March 9, 2011